

# Work Order ID 75176

**\*75176\***

Page 1

October-18-11 2:00:28 PM

Item ID: D2891-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 2.25 Support  
 Start Date: 18/10/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 29/11/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: M L J Date: 11/10/18 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2891                          | B                        |                      |         |        |              |               |               |                  |                |

100  
**\*100\*** HAAS CNC VERTICAL MACHINING #1 0.00 HA/11/11/07  
 HAAS I Memo 0.00 20 0  
 HAAS CNC vertical machine #1 1-Machine as per Folio FA046  
 2-Debur

110  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB 0.00 SL 10/11/08  
 QC Memo 0.00 20 0  
 Quality Control

120  
**\*120\*** QC8- Inspect parts - second check 0.00 SL 11/11/09  
 QC Memo 0.00 20 0  
 Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 75176

**\*75176\***

Page 2

October-18-11 2:00:28 PM

Item ID: D2891-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 2.25 Support  
 Start Date: 18/10/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 29/11/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID    | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><b>*130*</b><br>HandFXtube | <b>Memo</b>   | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing Crosstubes         | Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. | 0.00                 |         |        |              |               |               |                  |                |
| 140<br><b>*140*</b><br>QC         | <b>Memo</b>   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                   | QC3- Inspect Part Finish  | 0.00                 |         |        |              |               |               |                  |                |
| 170<br><b>*170*</b><br>Packaging  | Identify as per dwg & Stock Location: <u>X-tube</u>   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                         | <u>ASS'y</u><br><b>Memo</b>   | 0.00                 |         |        |              |               |               |                  |                |

vald.

AS

11 - 11 - 10

ST

11 - 11 - 10

(20)

11

11 - 10

(20)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 75176****\*75176\***

Page 3

October-18-11 2:00:28 PM

Item ID: D2891-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 2.25 Support

Start Date: 18/10/2011 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 29/11/2011 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

11/11/14

11-11-11  
20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

October-18-11 2:00:32 PM

Page 1

Work Order ID: 75176

**\*75176\***

Parent Item: D2891-1

**\*D2891-1\***

Parent Item Name: 2.25 Support

Start Date: 18/10/2011

Required Date: 29/11/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP C02.11.26Added P/OKJ

IPP D 08.03.19 Re-format EC verified: DD

IPP Rev:E

11.08.04 as per dwg rev.B DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| DSK076                          |                        | Manufactured  | No          |                     |                  | 110             | Each               | 3.0000         | 0.5         | 10           |               |                |        |

**\*DSK076\***

D2891-1 TURNING DETAIL

**\*\***

### Location

### Loc Qty

### Loc Code

MAT

3

72677

3

73944

10

10.0

B.A 11/11/07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                                    |                |                     |         |
|------------------------------------|----------------|---------------------|---------|
| <b>DART AEROSPACE LTD</b>          |                | <b>Work Order:</b>  | 75176   |
| <b>Description:</b> Ø2.250 Support |                | <b>Part Number:</b> | D2891-1 |
| <b>Inspection Dwg:</b> D2891       | <b>Rev:</b> A1 | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| HAAS Section  |       |       |                |                          |       |       |       |       |
| AA            | 0.188 | 0.193 |                | .190                     | .190  | .190  | .190  | .190  |
| AB            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AC            | 0.115 | 0.150 |                | .130                     | .130  | .130  | .130  | .130  |
| AD            | 0.040 | 0.060 |                | .050                     | .050  | .050  | .050  | .050  |
| AE            | 0.010 | 0.020 |                | .010                     | .010  | .010  | .010  | .010  |
| AF            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AG            | 0.290 | 0.310 |                | .300                     | .300  | .300  | .300  | .300  |
| AH            | 0.115 | 0.150 |                | .140                     | .140  | .140  | .140  | .140  |
| AI            | 0.454 | 0.474 |                | .465                     | .465  | .465  | .465  | .465  |
| AJ            | 2.779 | 2.789 |                | 2.784                    | 2.784 | 2.784 | 2.784 | 2.784 |
| AK            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AL            | 1.002 | 1.042 |                | 1.040                    | 1.040 | 1.040 | 1.040 | 1.040 |
| AM            | 0.053 | 0.073 |                | .06                      | .06   | .06   | .06   | .06   |
| AN            | 0.257 | 0.262 |                | .258                     | .258  | .258  | .258  | .258  |
| AO            | 1.663 | 1.683 |                | 1.080                    | 1.080 | 1.080 | 1.080 | 1.080 |
| AP            | 0.053 | 0.073 |                | .06                      | .06   | .06   | .06   | .06   |
| AQ            | 0.022 | 0.042 |                | .03                      | .03   | .03   | .03   | .03   |
| AR            |       |       |                |                          |       |       |       |       |
| AS            |       |       |                |                          |       |       |       |       |
| AT            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

|                                |                      |
|--------------------------------|----------------------|
| <b>Measured by:</b> SL / SA    | <b>Date:</b> 11/1/07 |
| <b>Audited by:</b> [Signature] | <b>Date:</b> 11/1/07 |
| <b>Prototype Approval:</b>     | <b>Date:</b>         |

| Rev | Date     | Change    | Revised by | Approved    |
|-----|----------|-----------|------------|-------------|
| A   | 02.12.12 | New Issue | KJ/RF      |             |
| B   | 08.04.21 | Reformat  | KJ/JLM     | [Signature] |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

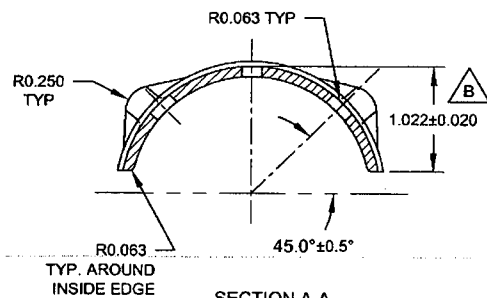
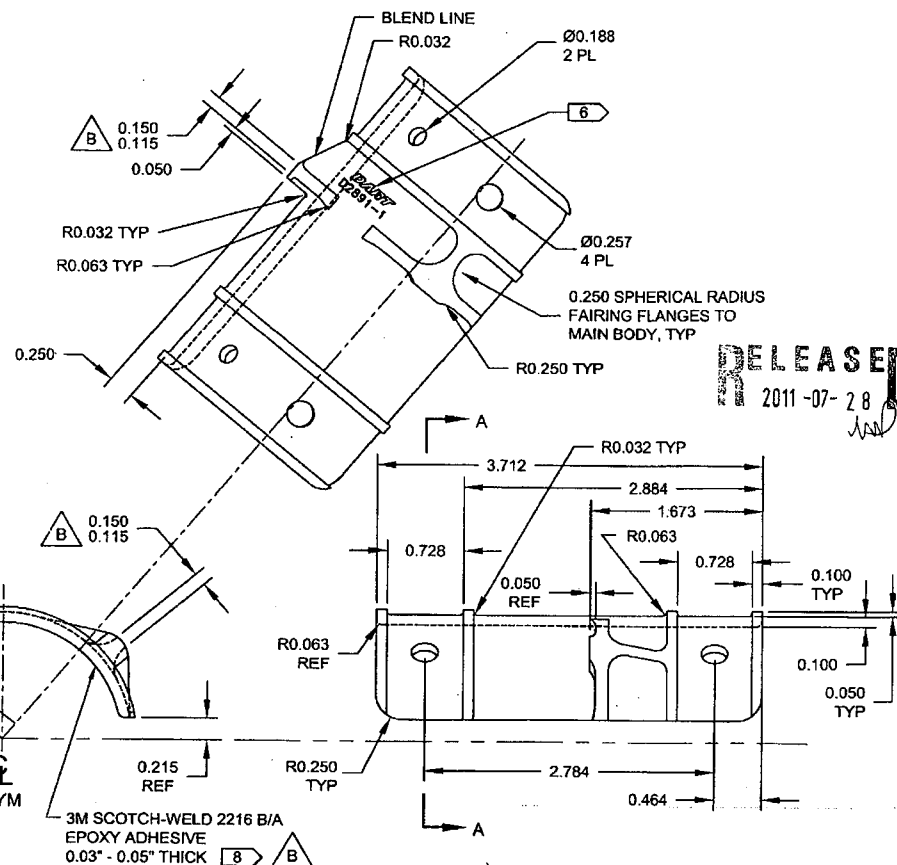
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**NOTES:**

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION  
MIN UTS = 170 KSI (38 HRC)  
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING  
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.38 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:  
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 75176 M.L.J  
11/10/18

| B          | RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION, UPDATE TOLERANCE (ZN D4-1, B4-1, B6-1) | CP | 11.07.15 |
|------------|--|----|----------|
| A          | NEW ISSUE  | CP | 00.11.17 |
| REV.       | DESCRIPTION  | BY | DATE     |
| DESIGN     |  |    |          |
| DRAWN      |  |    |          |
| CHECKED    |  |    |          |
| MFG. APPR. |  |    |          |
| APPROVED   |  |    |          |
| DE APPR.   |  |    |          |
| DATE       | 11.07.15   |    |          |

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2891  
TITLE Ø2.250 SUPPORT  
REV. B  
SHEET 1 OF 1  
SCALE  
NTS

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|                             |         |              |         |
|-----------------------------|---------|--------------|---------|
| DART AEROSPACE LTD          |         | Work Order:  | 75176   |
| Description: Ø2.250 Support |         | Part Number: | D2891-1 |
| Inspection Dwg: D2891       | Rev: A1 | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |        |        |        |         |
|---------------|-------|-------|----------------|--------------------------|--------|--------|--------|---------|
| Dim           | Min   | Max   | Go/No Go Gauge | 6<br>4                   | 7<br>2 | 8<br>3 | 9<br>4 | 10<br>5 |
| HAAS Section  |       |       |                |                          |        |        |        |         |
| AA            | 0.188 | 0.193 |                | .189                     | .189   | .189   | .189   | .189    |
| AB            | 0.240 | 0.260 |                | .254                     | .254   | .254   | .254   | .254    |
| AC            | 0.115 | 0.150 |                | .130                     | .130   | .130   | .130   | .130    |
| AD            | 0.040 | 0.060 |                | .05                      | .05    | .05    | .05    | .05     |
| AE            | 0.010 | 0.020 |                | .01                      | .01    | .01    | .01    | .01     |
| AF            | 0.240 | 0.260 |                | .25                      | .25    | .25    | .25    | .25     |
| AG            | 0.290 | 0.310 |                | .300                     | .300   | .300   | .300   | .300    |
| AH            | 0.115 | 0.150 |                | .140                     | .140   | .140   | .140   | .140    |
| AI            | 0.454 | 0.474 |                | .464                     | .464   | .464   | .464   | .464    |
| AJ            | 2.779 | 2.789 |                | 2.784                    | 2.784  | 2.784  | 2.784  | 2.784   |
| AK            | 0.240 | 0.260 |                | .25                      | .25    | .25    | .25    | .25     |
| AL            | 1.002 | 1.042 |                | 1.04                     | 1.04   | 1.04   | 1.04   | 1.04    |
| AM            | 0.053 | 0.073 |                | .06                      | .06    | .06    | .06    | .06     |
| AN            | 0.257 | 0.262 |                | .258                     | .258   | .258   | .258   | .258    |
| AO            | 1.663 | 1.683 |                | 1.678                    | 1.678  | 1.678  | 1.678  | 1.678   |
| AP            | 0.053 | 0.073 |                | .063                     | .063   | .063   | .063   | .063    |
| AQ            | 0.022 | 0.042 |                | .032                     | .032   | .032   | .032   | .032    |
| AR            |       |       |                |                          |        |        |        |         |
| AS            |       |       |                |                          |        |        |        |         |
| AT            |       |       |                |                          |        |        |        |         |
| Accept/Reject |       |       |                |                          |        |        |        |         |

|                        |                |
|------------------------|----------------|
| Measured by: <i>SK</i> | Date: 11/11/08 |
| Audited by: <i>AK</i>  | Date: 11/11/09 |
| Prototype Approval:    | Date:          |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 02.12.12 | New Issue | KJ/RF      |          |
| B   | 08.04.21 | Reformat  | KJ/JLM     |          |



|                             |         |              |         |
|-----------------------------|---------|--------------|---------|
| DART AEROSPACE LTD          |         | Work Order:  | 75176   |
| Description: Ø2.250 Support |         | Part Number: | D2891-1 |
| Inspection Dwg: D2891       | Rev: A1 | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| HAAS Section  |       |       |                |                          |       |       |       |       |
| AA            | 0.188 | 0.193 |                | .189                     | .189  | .189  | .189  | .189  |
| AB            | 0.240 | 0.260 |                | .252                     | .252  | .252  | .252  | .252  |
| AC            | 0.115 | 0.150 |                | .130                     | .130  | .130  | .130  | .130  |
| AD            | 0.040 | 0.060 |                | .050                     | .050  | .050  | .050  | .050  |
| AE            | 0.010 | 0.020 |                | .01                      | .01   | .01   | .01   | .01   |
| AF            | 0.240 | 0.260 |                | .25                      | .25   | .25   | .25   | .25   |
| AG            | 0.290 | 0.310 |                | .300                     | .300  | .300  | .300  | .300  |
| AH            | 0.115 | 0.150 |                | .140                     | .140  | .140  | .140  | .140  |
| AI            | 0.454 | 0.474 |                | .464                     | .464  | .464  | .464  | .464  |
| AJ            | 2.779 | 2.789 |                | 2.784                    | 2.784 | 2.784 | 2.784 | 2.784 |
| AK            | 0.240 | 0.260 |                | .250                     | .250  | .250  | .250  | .250  |
| AL            | 1.002 | 1.042 |                | 1.04                     | 1.04  | 1.04  | 1.04  | 1.04  |
| AM            | 0.053 | 0.073 |                | .063                     | .063  | .063  | .063  | .063  |
| AN            | 0.257 | 0.262 |                | .258                     | .258  | .258  | .258  | .258  |
| AO            | 1.663 | 1.683 |                | 1.68                     | 1.68  | 1.68  | 1.68  | 1.68  |
| AP            | 0.053 | 0.073 |                | .06                      | .06   | .06   | .06   | .06   |
| AQ            | 0.022 | 0.042 |                | .032                     | .032  | .032  | .032  | .032  |
| AR            |       |       |                |                          |       |       |       |       |
| AS            |       |       |                |                          |       |       |       |       |
| AT            |       |       |                |                          |       |       |       |       |
| Accept/Reject |       |       |                |                          |       |       |       |       |

|                             |                |
|-----------------------------|----------------|
| Measured by: <i>BC / SA</i> | Date: 11/11/08 |
| Audited by: <i>AMX</i>      | Date: 11/11/09 |
| Prototype Approval:         | Date:          |

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 02.12.12 | New Issue | KJ/RF      |                    |
| B   | 08.04.21 | Reformat  | KJ/JLM     | <i>[Signature]</i> |





|                             |         |              |         |
|-----------------------------|---------|--------------|---------|
| DART AEROSPACE LTD          |         | Work Order:  | 75176   |
| Description: Ø2.250 Support |         | Part Number: | D2891-1 |
| Inspection Dwg: D2891       | Rev: A1 | Page 1 of 1  |         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |         |         |         |         |
|---------------|-------|-------|----------------|--------------------------|---------|---------|---------|---------|
| Dim           | Min   | Max   | Go/No Go Gauge | 16<br>1                  | 17<br>2 | 18<br>3 | 19<br>4 | 20<br>5 |
| HAAS Section  |       |       |                |                          |         |         |         |         |
| AA            | 0.188 | 0.193 |                | .189                     | .189    | .189    | .189    | .189    |
| AB            | 0.240 | 0.260 |                | .254                     | .254    | .254    | .254    | .254    |
| AC            | 0.115 | 0.150 |                | .130                     | .130    | .130    | .130    | .130    |
| AD            | 0.040 | 0.060 |                | .05                      | .05     | .05     | .05     | .05     |
| AE            | 0.010 | 0.020 |                | .01                      | .01     | .01     | .01     | .01     |
| AF            | 0.240 | 0.260 |                | .25                      | .25     | .25     | .25     | .25     |
| AG            | 0.290 | 0.310 |                | .300                     | .300    | .300    | .300    | .300    |
| AH            | 0.115 | 0.150 |                | .140                     | .140    | .140    | .140    | .140    |
| AI            | 0.454 | 0.474 |                | .464                     | .464    | .464    | .464    | .464    |
| AJ            | 2.779 | 2.789 |                | 2.784                    | 2.784   | 2.784   | 2.784   | 2.784   |
| AK            | 0.240 | 0.260 |                | .25                      | .25     | .25     | .25     | .25     |
| AL            | 1.002 | 1.042 |                | 1.04                     | 1.04    | 1.04    | 1.04    | 1.04    |
| AM            | 0.053 | 0.073 |                | .06                      | .06     | .06     | .06     | .06     |
| AN            | 0.257 | 0.262 |                | .258                     | .258    | .258    | .258    | .258    |
| AO            | 1.663 | 1.683 |                | 1.678                    | 1.678   | 1.678   | 1.678   | 1.678   |
| AP            | 0.053 | 0.073 |                | .063                     | .063    | .063    | .063    | .063    |
| AQ            | 0.022 | 0.042 |                | .032                     | .032    | .032    | .032    | .032    |
| AR            |       |       |                |                          |         |         |         |         |
| AS            |       |       |                |                          |         |         |         |         |
| AT            |       |       |                |                          |         |         |         |         |
| Accept/Reject |       |       |                |                          |         |         |         |         |

|                             |                       |
|-----------------------------|-----------------------|
| Measured by: <u>SG / SA</u> | Date: <u>11/11/09</u> |
| Audited by: <u>CMZ</u>      | Date: <u>11/11/09</u> |
| Prototype Approval:         | Date:                 |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 02.12.12 | New Issue | KJ/RF      |          |
| B   | 08.04.21 | Reformat  | KJ/JLM     |          |

